

Work Order ID 65079

Thursday, January 06, 2011 9:13:07 AM



Page 1

Item ID: D4154-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 1/6/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-01-6

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4154

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304: 050

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

2-Deburr if necessary

B11-1-6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 1/6/11

(+6)

QC

Memo

0.00

Quality Control

130

Form as per dwg

0.00

S 1/10/11

(6)

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

S 1/10/11

(+6)

QC

Memo

0.00

Quality Control

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Page 3

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Stop



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Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: W/A

0.00



Packaging

Memo

0.00

Packaging

EL 11-1-12 (26)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12 (Signature)

MF
11-01-12

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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 9:13:11 AM

Page 1

Work Order ID: 65079

Parent Item: D4154-1

Parent Item Name: Plate



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	84.6200	4.2697	26.96653			



304/316 .050 Sheet



B11-1-6

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	58	
116135	58	
MAT20	26.62	
111743	4.75	
113062	20.77	
115389	1.1	

116135

6

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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.09.23	New Issue	KJ 	

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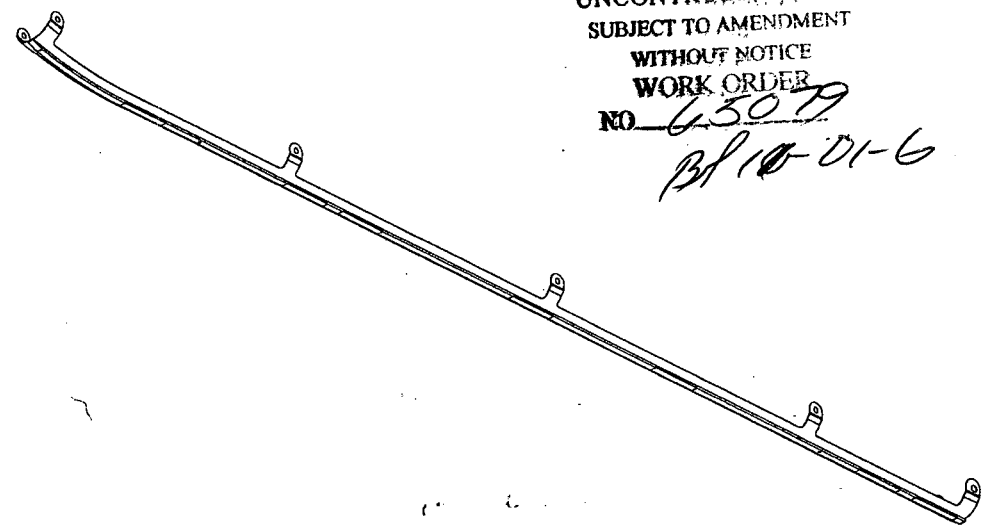
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 63079
3/10-01-6



D4154-041 WEARPLATE ASSEMBLY

RELEASED
 2010-09-15
MP

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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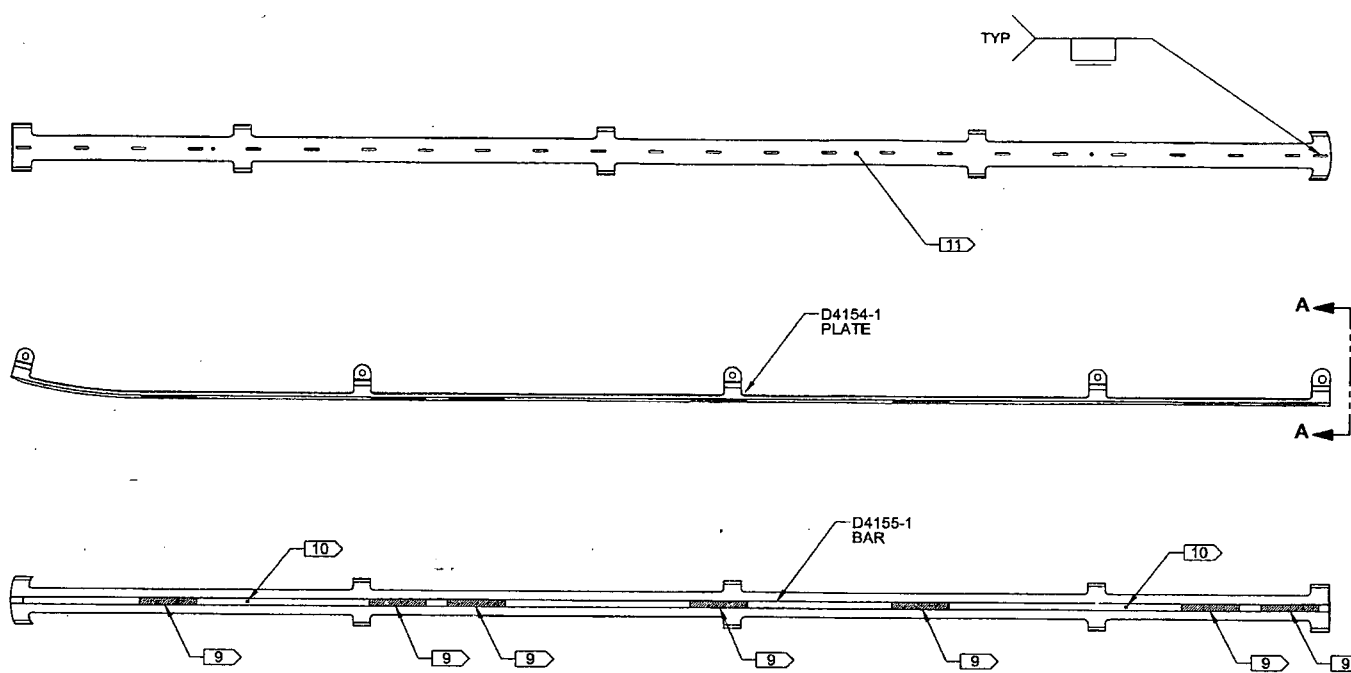
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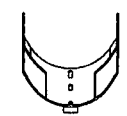
NOTE: Date & initial all entries

WLO 45079



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15



SECTION A-A

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 5.99 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
 - 10) TRANSFER DRILL Ø0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
 - 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4154	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSEMBLY	NTS
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Dart Aerospace Ltd

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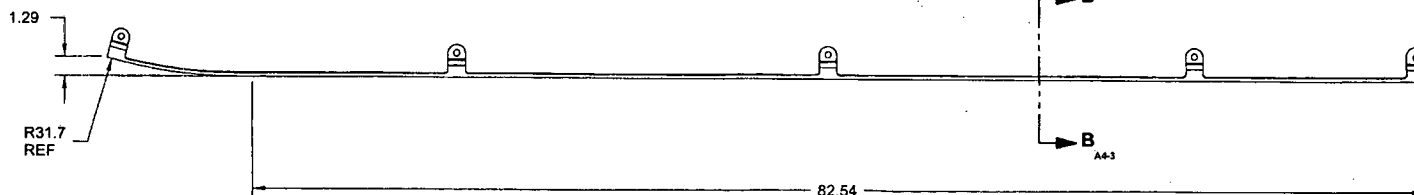
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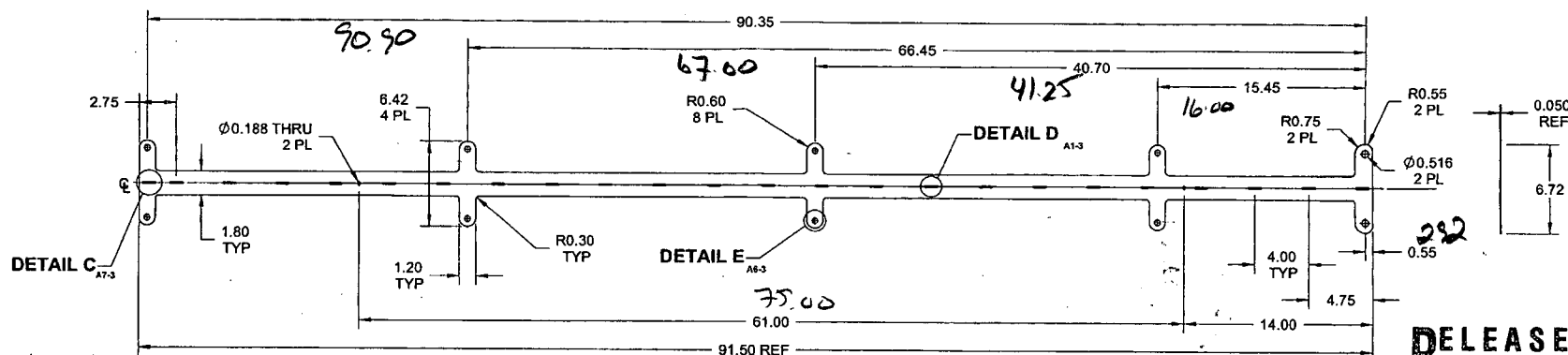
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



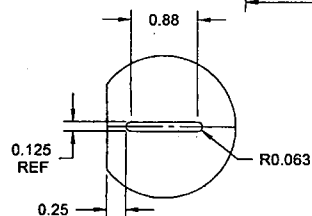
D4154-1 PLATE
(MAKE FROM D4154-1F)

W1065079

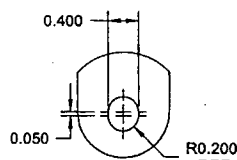


D4154-1F FLAT PATTERN

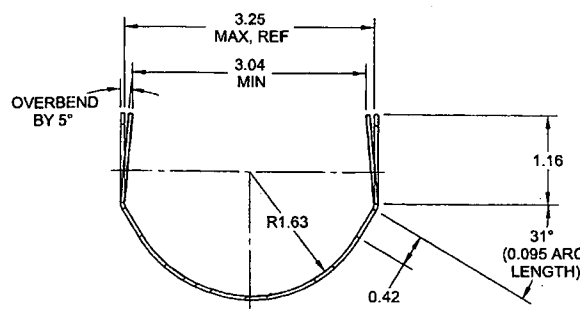
RELEASED
R 2010-09-15
W



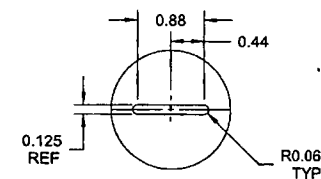
DETAIL C
C7-3
SLOT DETAIL TYP



DETAIL E
C4-3
SLOT DETAIL TYP




SECTION B-B
D3-3



DETAIL D
C4-3
SLOT DETAIL TYP

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.71 lbs

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MFG. APPR.		D4154	SHEET 3 OF 3
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